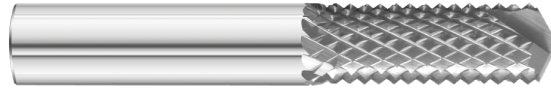


**M.A.T.R.X**



**5600 Series - MATRX Composite Burr/Routers**

Available in Style A - No End Cut, Style B - Burr Style End Cut, Style C - End Mill End Cut, and Style D - 135° Drill Point

Flute Diameter	Carbon, Carbon Graphite, Unfilled Plastics		Composites		Fiber Reinforced Plastics		Green Ceramics, Green Carbide	
	Speed SFM	Feed IPR	Speed SFM	Feed IPR	Speed SFM	Feed IPR	Speed SFM	Feed IPR
1/8"	400-800	.0008-.0025	400-800	.0004-.0008	400-800	.0004-.0008	400-800	.0004-.0008
3/16"	600-1500	.0015-.003	400-800	.0005-.001	400-800	.0005-.001	600-1500	.0008-.002
1/4"	600-1500	.0025-.004	400-800	.0008-.002	400-800	.0008-.002	600-1500	.0015-.003
5/16"	600-1500	.003-.005	400-800	.0025-.004	400-800	.0025-.004	600-1500	.0025-.004
3/8"	600-1500	.004-.0065	400-800	.003-.0055	400-800	.003-.0055	600-1500	.003-.0055
1/2"	600-1500	.0065-.008	400-800	.005-.007	400-800	.005-.007	600-1500	.005-.007

The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool.

If a coating is applied to the tools, the SFM can be increased by approximately 25%.

All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.

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